

RUSH

Date: Thursday, 12/07/2007 9:20:10 AM
User: Linda Lacelle



Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WASHER
Job Number :	33519		
Estimate Number :	11218		
P.O. Number :	N/A	Part Number :	D34173
This Issue :	12/07/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3417 REV C
First Issue :	N/A	Project Number :	N/A
Previous Run :	27644	Drawing Revision :	C
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	19/07/2007
Written By :			Qty: 40 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A 05.10.19 New issue KJ/EC Est Rev:B 05.10.19 added haas op. EC		



Additional Product

Job Number: 



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNR12500	DELRLIN ROUND BAR 1.25"
		
Comment: Qty.: 0.0311 f(s)/Unit Total: 1.2432 f(s) Material: Delrin Round Bar Ø1.250 (M-DELRLIN-R1.250) Batch: <u>M 104398</u> Identify for D3417-3		

S.F. 07/07/24



2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA594 Rev: <u>C</u> & Dwg D3417 Rev: <u>C</u> 2-Deburr		

S.F. 07/07/24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

(103)

S.F. 07/07/24





4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 -Machine as per folio FA594 rev. <u>C</u> & dwg D3417 rev. <u>C</u>		

SA 010121 (89)

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 2 Date: 01/01/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/01/25	4.0	- 14 parts flew off two-way. Lape sig while machining		- scrap parts no replace destroy	SD 01/01/25			

NOTE: Date & initial all entries

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Drawing Name: WASHER

Job Number: 33519

Part Number: D34173

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 01.01.24

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/07/25

(89)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST100

07/17/26

(89)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

01/07/26

(89)

Job Completion



U 01.01.26

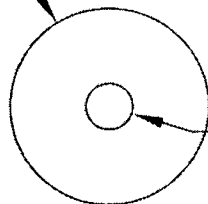


DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3417	REV. C SHEET 1 OF 1
DATE 05.06.30		TITLE WASHER	SCALE 1:1
A	05.03.31	NEW ISSUE	
B	05.06.10	CHANGE TO ROUND WASHER	
C	05.06.30	REMOVE C'BORE, WIDEN	

RELEASED

05.11.14 [Signature]

$\phi 1.125^{+0.030}_{-0.000}$



$\phi 0.265^{+0.005}_{-0.000}$

R1.87

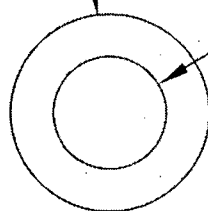
0.409



0.320



$\phi 1.125^{+0.030}_{-0.000}$



$\phi 0.640^{+0.005}_{-0.000}$

R1.87

0.346



0.260



D3417-1 WASHER

D3417-3 WASHER

D3417-1/-3 WASHER

- 1) MATERIAL: DELRIN (REF. DART SPEC. M-DELIN-R1.250)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

